



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6510G04631-6F-6
Job Sheet 199037



Part No: RBW6510G04631-6F-6

Job Qty: *2 pcs*

Part Name: Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/9/19

Job Tracking No:

Due Date: 10/21/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6510G04631-6F Rev A IPP Rev. A 19.08.08 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter / Supplier Lead Time	Sign-off
					Setup Hrs	Run Hrs		
100	NV5000 - 1	2 pcs	10/21/19	10/21/19	1.00	0.50	NV5000 - 1	<i>ALA./cmk 19-9-19</i>
							NV5000 - 2	
110	QC 2	2 pcs	10/21/19	10/21/19	0.00	0.00	QC 2 - 1	<i>ALA./cmk 19-9-19</i>
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	
							QC 2 - 66	
							QC 2 - 64	



Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL : 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S215693



Part: RBW6510G04631-6F-6

Job No: 199037

Serial No/Batch: S215693

Revision: A

Inspector:

Exp Date:

Instructions:

Date: 09/20/19

120 QC 8	2 pcs	10/21/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	B.E 19-09-21
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
125 Outsource - 12 - Black Oxide	2 pcs	10/21/19		GRO002-VC	2019-09-23
126 Packaging 2-1 - Receive - B4B	2 pcs	10/21/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	SEP 27 2019
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
127 QC 6	2 pcs	10/21/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	DAS 81 OCT 04 2019
				QC 6 - 40	9-89
				QC 6 - 81	
130 Packaging 3-1 - Stock - B4B	2 pcs	10/21/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	DAS 28
				Packaging 3 - 3 - B4B	9-89
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
140 QC 21 - SA	2 pcs	10/21/19	0.00 0.00	QC 21 - SA - 21	DAS 21
				QC 21 - SA - 70	9-89 OCT 08 2019
				QC 21 - SA - 53	

Part Op 100 - 1-Machine as per folio FC 990 FOLIO REV: AA DWG REV: A 2-Deburr
Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB
120 - QC8- Inspect parts - second check
125 - -Issue P/O; 44559 -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type;
4140 -Certificate of Conformity is required

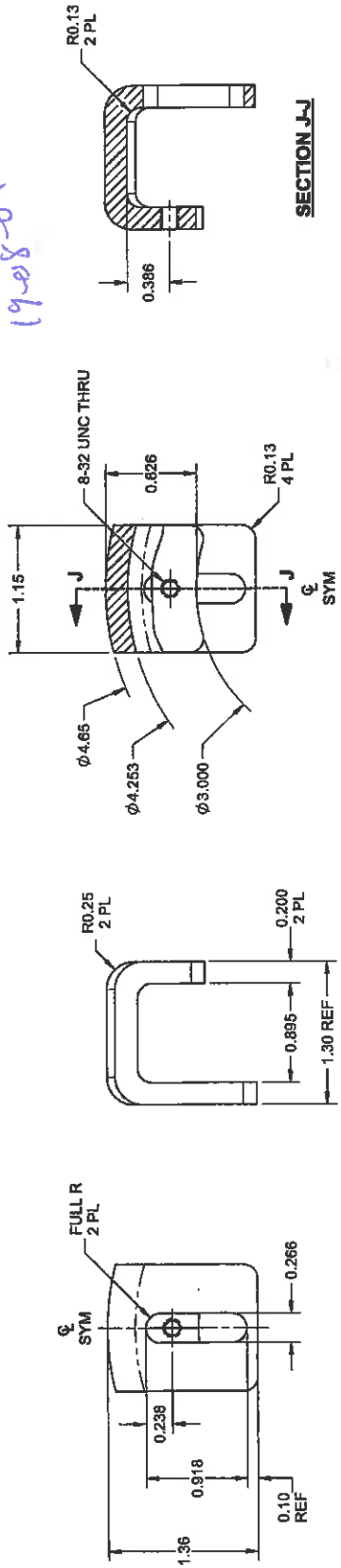
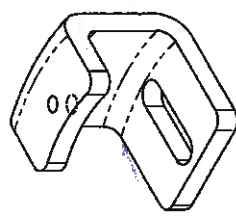
- 126 - (Receive & Inspect for Damage & Mat'l Certs) C of C required.
- 127 - QC6- All purchased or subcontracted products
- 130 - Identify as per dwg & Stock Location: _____
- 140 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
MT-4140-B-1,500X2,000	4140 Steel Bar 1,500 X 2,000	.2250 ft (.1125 ea)	100-NV5000 - 1	5149964
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-NV5000 - 1	MT-4140-B-1,500X2,000	0	1	0
Part Specifications				
Specifications could not be found.				

cut
1.36'

Plex 8/9/19 2:09 PM Dart.lajeunesse.marie

SHOP COPY
RETURN TO
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 199037 M5
1908-09



NOTES:
1) MATERIAL: 4140 (28-32 RC)
2) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF
OR MIL-C-22411A OR MIL-PRF-81308 AND WIPE OFF EXCESS
3) TOLERANCES: XX = ± 0.01 / ± 0.5
XXX = ± 0.005 / ± 0.1
XXXX = ± 0.0005 / ± 0.05
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = ± 0.005
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) REMOVE ALL SHARP EDGES AND BURRS
7) IDENTIFICATION: N/A

DESIGN	DRAWN	CHECKED	MFG. APPR.	APPROVED	DATE	2019-07-09
KPT	KPT	VM	PK	W		
TOOL PART #	RBW6510G04631-8F	TITLE	REACTION ASSEMBLY	SCALE	NTS	REV. A
DART AEROSPACE LTD	HAWKESBURY, ONTARIO, CANADA					SHEET 8 OF 10

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Quality ☐															
Date : _____		Sequence # : _____		QTY Affected : _____		MRB (QS1042)													
Description Work Order Deviation				Disposition				Completed By											
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY															
				Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____				Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐				Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐				Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
QC / QA Coordinator																			



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PURCHASE ORDER **POHB044559**



Supplier: GRO002-VC Group Altech 2455 Halpern St Laurent QC H4S 1N9 Canada Phone: 514-335-3666 Fax: 514-335-3868 Attention: Grenon, Sylvie Ship To: 1270 Aberdeen Street Hawkesbury ON K6A 1K7 Canada Phone: 613-632-5200	PO No: POHB044559 PO Date: 9/23/19 Due Date: 10/1/19 Purchase Order Revision: Revision Date: Ship-To Contact: Guerin, Kimberley Phone: 613-632-5200 Ext: 298 kguerin@dartaero.com Via: Ground Pymt Terms: Net 60 Freight Terms: Special Comments:
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E-MAILED
2019-09-23

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	199047	RBW6510G05731-6F-2	Support -Issue P/O: -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed		10/1/19	6 pcs	0 pcs	6 pcs	\$6.95/pcs	\$41.70
				X6			SEP 27 2019				DP
2	199141	RBW6522A00231-W142AJ-3T-5A	Insert (Outside Processing - Black Oxide) -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed		10/1/19	6 pcs	0 pcs	6 pcs	\$2.69/pcs	\$16.14
				X6			SEP 26 2019				DP



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PURCHASE ORDER POHB044559



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	199037	RBW6510G04631-6F-6	Bracket -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	10/1/19	12 pcs	0 pcs	12 pcs	\$1.85/pcs	\$22.20
							SEP 26 2019				DP
4	197520	RBE350A94-2706-00-01	Pin -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	10/1/19	50 pcs	0 pcs	50 pcs	\$2.50/pcs	\$125.00
							SEP 26 2019				DP
5	199255	RBST4241-15	Locating Pin -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required	Firmed	-	10/1/19	12 pcs	0 pcs	12 pcs	\$1.23/pcs	\$14.76
							SEP 27 2019				DP
Grand Total:										\$219.80	



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PURCHASE ORDER
POHB044559



Order Notes

Procurement Quality Clauses

- A005 right of entry
- A012 chemical and physical test report
- A016 personnel qualification
- A017 raw material identification (as applicable)

- A022 Apical Processing
- A024 process certifications
- A026 certification of material conformance

- A041 quality management system
- A042 dart notification by supplier
- A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/24/19 12:55 PM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(022664-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

022664 - 1

SEP 26 2019

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
26-Sep-2019		Jigar Patel			POHB044559			
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBW6510G05731-6F-2 Rev.	RBW6510G05731-6F-2 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	6	6	0	0	0
2	RBW6522A00231-W142AJ-3T-5A Rev.	RBW6522A00231-W142AJ-3T-5A OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	6	6	0	0	0
3	RBW6510G04631-6F-6 Rev.	RBW6510G04631-6F-6 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	12	12	0	0	0
4	RBE350A94-2706-00-01 Rev.	RBE350A94-2706-00-01 SAND BLAST ALL OVER OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	50	50	0	0	0
5	RBST4241-15 Rev.	RBST4241-15 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	12	12	0	0	0

DAS
81
9-89

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Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.